

Work Order ID 71077

Tuesday, June 21, 2011 3:37:17 PM



Page 1

Item ID: D212-722-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Dzus Rail Brace

Start Date: 6/21/2011 Start Qty: 11.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 11.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 11-06-22

Tooling:

Date:

Run Start



QC: _____ Date: _____

SPC (Y/N): _____

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI 9476	A
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100

0.00



DC

Memo

0.00

Document Control

Photocopie DSI 9476 and labels per PPP D212-722-013

CH6001

11 06 29 (11)
for CL 11-6-28

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11 06 29 (11)
for CL 11-6-28

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

11 06 29 (11)
for CL 11-6-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71077

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Page 2

Item ID: D212-722-013

Accept



Setup Start



Revision ID:

Item Name: Dzus Rail Brace

Stop



Start Date: 6/21/2011 Start Qty: 11.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 11.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo Identify and pack for shipping as per PPP D212-722-013 Location: _____ PPP rev: _____	0.00							<i>cu/e/28 (11)</i>
140									
	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							<i>n/6/30</i>
Quality Control									

u 6.06.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 3:37:11 PM

Page 1

Work Order ID: 71077

Parent Item: D212-722-013

Parent Item Name: Dzus Rail Brace



Start Date: 6/21/2011

Required Date: 6/24/2011

Start Qty: 11.00

Required Qty: 11.00

Comments: IPP revA 11.06.21 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D3986-1 Angle		Manufactured	No			110	Each	0.0000	11	11			
 D3986-3 Brace		Manufactured	No			110	Each	0.0000	22	22			



B 71078

(X11)

B 71094

x22

CL 11/06/28

CL 4/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Option 2 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has not been removed from aircraft:

Note: The existing PR35 center dzus rails will need to be removed and re-worked to a correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the PR35 center dzus rails from the existing dzus rail brace. Remove dzus rail.
- 2) Without removing it, trim the existing left dzus rail brace, as shown in Figure 4 (Sheet 6). Trim the existing right dzus rail brace 2.25" longer. See Note 1 Figure 4 (Sheet 6).
- 3) Trim D3986-3 braces so that when matched with the existing dzus rail braces the original D3986-3 length is maintained.
- 4) Clamp and cleco the D3986-1 angle, the trimmed D3986-3 braces and PR35 dzus rail together as shown in Figure 3 (Sheet 5).
- 5) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 6) Transfer drill $\varnothing 0.129$ (#30 drill) the necessary holes (4 typ) from PR35 dzus rail thru D3986-3 braces. See Figure 3, (Sheet 5), Note 1.
- 7) Deburr holes and reassemble using clecos.
- 8) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 3, (Sheet 5), Note 2.
- 9) Deburr holes and reassemble using clecos.
- 10) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft console. See Figure 3, (Sheet 5), Note 3.
- 11) Deburr holes, dimple D3986-1 angle and aircraft console and reassemble using clecos.
- 12) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails
- 13) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 3 (Sheet 5) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

WEIGHT AND BALANCE

Compliance with this DSI has no effect on the aircraft weight and balance.

PARTS LIST

QTY. -013	PART NUMBER	DESCRIPTION
X	D212-722-013	DZUS RAIL BRACE KIT
1	D3986-1	ANGLE
2	D3986-3	BRACE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 11.06.01
CERT. NO.: SH05-11
ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9476	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DZUS RAIL BRACE KIT	NTS
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